

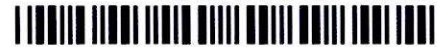


Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3276-3

Job Sheet 216007



6 PL

Part No: D3276-3

Job Qty: 4 pcs

Part Name: Placard



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/26/20

Job Tracking No:

Due Date: 12/11/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP A 05.02.14 New issue KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard	Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs / Supplier Lead Time	
100	Purchasing	4 pcs	12/11/20	12/11/20	0.00	0.00	Purchasing - 1 Purchasing - 2 Purchasing - 3
110	Packaging 2-1 - Receive - B4B	4 pcs	12/11/20	12/11/20	0.00	0.00	Packaging 2 - 1 - B4B Packaging 2 - 2 - B4B Packaging 2 - 3 - B4B Packaging 2 - 5 - B4B Packaging 2 - 4 - B4B Packaging 2 - 6 - B4B Packaging 2 - 7 - B4B Packaging 2 - 8 - B4B Packaging 2 - 9 - B4B Packaging 2 - 10 - B4B Packaging 2 - 11 - B4B Packaging 2 - 12 - B4B Packaging 2 - 13 - B4B Packaging 2 - 14 - B4B Packaging 2 - 15 - B4B Packaging 2 - 16 - B4B Packaging 2 - 17 - B4B Packaging 2 - 18 - B4B Packaging 2 - 19 - B4B Packaging 2 - 20 - B4B Packaging 2 - 21 - B4B Packaging 2 - 22 - B4B Packaging 2 - 23 - B4B Packaging 2 - 24 - B4B Packaging 2 - 25 - B4B Packaging 2 - 26 - B4B Packaging 2 - 27 - B4B Packaging 2 - 28 - B4B



Container No: S319023



Part: D3276-3

Job No: 216007

Serial No/Batch: S319023

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 12/08/20

Plex 11/26/20 8:25 AM Dart.lajeunesse.marie

				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
				Packaging 2 - 37 - B4B	
120	QC 6	4 pcs	12/11/20	0.00 0.00	QC 6 - 9
					QC 6 - 68
					QC 6 - 61
					QC 6 - 40
					QC 6 - 81
					QC 6 - 82
					QC 6 - SCH-B
130	Packaging 3-1 - Stock - B4B	4 pcs 6Pcs ✓	12/11/20	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B ✓
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
					Packaging 3 - 37 - B4B
140	QC 21 - SA	4 pcs	12/11/20	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 9
					QC 21 - SA - 77
					QC 21 - SA - 28

Part Op 100 - (Purchasing) Issue P/O: 46047764

For D3276-3 decal as per Dwg D3276 Possible Supplier: Studio Lettrage

x  NOV 26 2020 8:25 AM Dart.lajeunesse.marie

Descriptions: Material release note is required

110 - (Receive & Inspect for Damage & Mat'l Certs) Ensure Material Release Note is attached

130 - ***ONE YEAR EXPIRED DATE FROM RECEIVING: _____ ***

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3276-3P	Decal	4 pcs (1 ea)	100-Purchasing	S319016

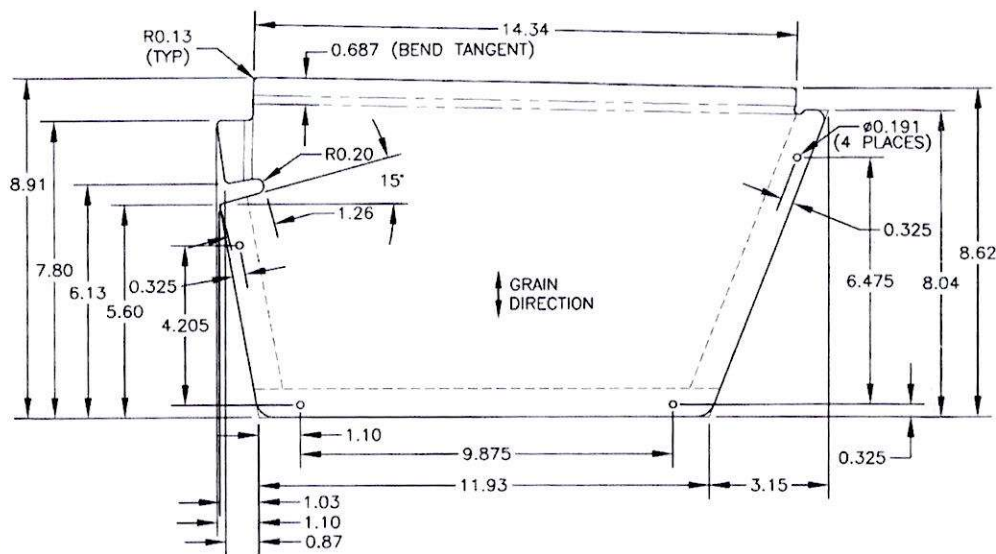
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	D3276-3P	4	0	0

Part Specifications

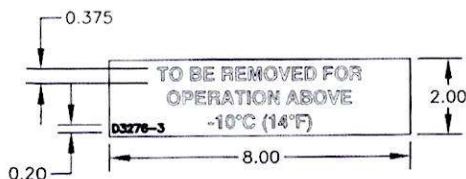
Specifications could not be found.

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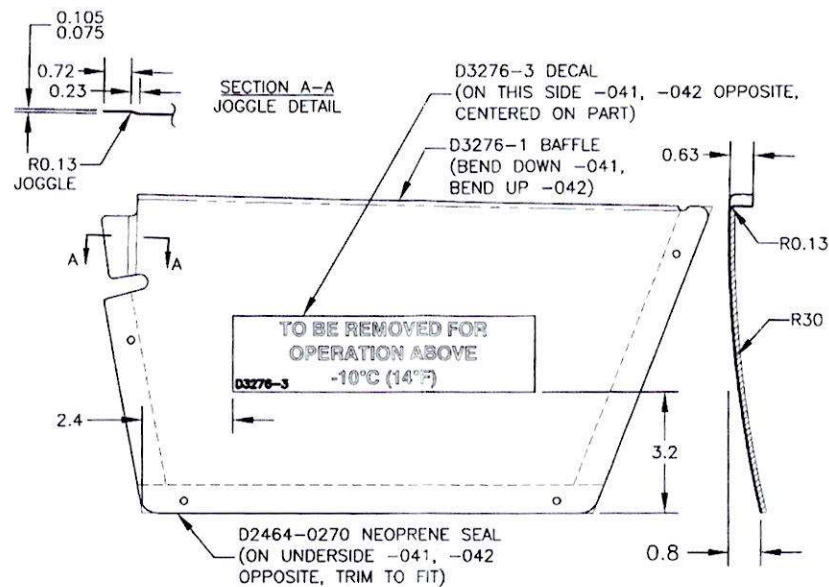
D3276-1 BAFFLE (FLAT PATTERN)

- 1) MACHINE PER DWG FILE "D3276-A.DWG"
- 2) MATERIAL: 6061-T6 ALUMINUM 0.040 THICK (QQ-A-250/11)
(REF DART SPEC. M6061T6S.040)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D3276-3 DECAL

- 1) RED LETTERING ON WHITE ADHESIVE BACK
- 2) MANUFACTURE FROM 3M 7 MIL MASKING FILM #8522CP OR AVERY IPM #2031
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D3276-041 BAFFLE ASSEMBLY, LH (SHOWN) D3276-042 BAFFLE ASSEMBLY, RH (BEND/JOGGLE OPPOSITE)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 216007 ML5
2011-26

RELEASED
05 02 02

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THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

B	05.01.25	LABEL NOW -10°C; CURVE PART
A	05.01.07	NEW ISSUE
DESIGN	CP	DRAWN BY CP
CHECKED	✓	APPROVED
DATE	05.01.25	TITLE
		BAFFLE ASSEMBLY
		DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
		DRAWING NO. D3276
		REV. B
		SHEET 1 OF 1
		SCALE 1:3

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB047764



Supplier: STU002-VC
Studio de Lettrage 2001
210 Main West
Hawkesbury
ON
K6A 2H6 Canada
Phone: 613 632 5449
Fax: 613 632 9491

Attention: Grace, Batista

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB047764

PO Date: 11/26/20

Due Date: 12/10/20

**Purchase Order
Revision:**

Revision Date:

Issued By: Lussier, Patrick
Phone: 613-632-5200 Ext: 276
plussier@dartaero.com

Via: Ground

Pynt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Drawing	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	216007	D3276-3P	D3276 Rev B			Decal : Various STC's As per Dwg D3276 Rev. B	Firmed -		12/10/20	6 pcs	0 pcs	6 pcs	\$13.3333/pcs	\$80.00
							X/b			DEC 08 2020				
2	215843	600.1347P				C10 Warning Label	Firmed -		12/10/20	20 pcs	0 pcs	20 pcs	\$4.00/pcs	\$80.00
							X/20			DEC 08 2020				
Grand Total:														\$160.00

DAS
40
9-89

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Please ensure to send the related invoice to hby_ap@dartaero.com.

Plex 11/26/20 2:25 PM dart.lussier.patrick

*** CERTIFICATE of CONFORMITY ***				
Manufacture: <u>Studio SL2</u>				
Purchase order #:	Packing Slip#	Part #:	Drawing Rev:	Serial/Batch:
<u>HBO47664</u>	<u>WO#28050</u>		<u>B</u>	
Description (Part Name):			Quantity:	
<u>D3276-3P, 600.1347P</u>			<u>6, 20</u>	
Certification: We hereby certify that:				PLEASE CHECK BOX IF REQUIRED
1. The above listed items were manufactured and/or inspected in accordance with applicable supplied drawings and/or specifications.				☒
2. All work was accomplished in accordance with the Dart Aerospace Ltd. purchase order.				☒
3. Results of all inspections, chemical or physical test, as well as other evidence, which shows the acceptability of raw materials, parts and/or assembly components are on file and available for inspection at any time.				☒
4. All material certification or copies of purchase orders of the material used to manufacture this component have been attached to this document.				☒
Record Expiry Date of Materials: <u>Dec 7, 2021</u>				
Authority: <u>3m</u>				
Approval:		Date: (yyyy/mm/dd)		
<u>Valerie Young</u>		<u>2020/12/07</u>		
Signature:		Title:		
<u>Val</u>		<u>Office admin.</u>		

DAS
40
9-89

studio sl2

210 Main West
Hawkesbury, Ontario K6A 2H6
Canada

INVOICE

Invoice No.: 50367
Date: 12/07/2020
Ship Date:
Page: 1
Re: Order No.

Sold to:

Dart Aerospace Ltd

1270 Aberdeen
Hawkesbury, Ontario
K6A 1K7

Ship to:

Dart Aerospace Ltd

1270 Aberdeen
Hawkesbury, Ontario
K6A 1K7

825007651RT0001

Quantity	Description	Base Price	Disc. %	Unit Price	Tax code	Amount
6	D3276-3P.	13.3333		13.3333	H	80.00
20	600.1347.P. ✓	4.0000		4.0000	H	80.00
	PO# HB047764					
	Attn: Patrick					
	Subtotal:					160.00
	H - HST					
	HST					20.80
 RECEIVED DEC 07 2020 DART AEROSPACE LTD. <i>Thank you for your business / Merci de faire affaire avec nous</i>						

Shipped By:

Tracking Number:

HST: 825007651RT0001

Total Amount

180.80

Comment: WO28050

Amount Paid

0.00

Sold By:

Amount Owning

180.80

IJ35-10
IJ35-20**Quick Links**

[3M Graphics Warranties](#)
[Technical Information Selector](#)
[Safety Data Sheets \(SDS\)](#)
[Flammability \(ASTM E84 Reports\)](#)
[Videos](#)

Product Description

- For Solvent, Eco-Solvent UV and Latex Inkjet Printing and Screen Printing
- 3.2-mil vinyl film

Product Features

- Available in gloss and matte finishes
- Pressure-sensitive adhesive
- Permanent
- Expected Performance Life of 5 years (unwarranted period for unprinted film with no graphic protection, applied to a flat, vertical, outdoor surface)

Recommended Types of Graphics and End Uses

- Short to long-term, indoor and outdoor promotional graphics
- Signs, trade show and point-of-purchase displays
- Exhibits and architectural applications

Graphic Protection

Graphic protection can improve the appearance, performance and durability of your graphic. Always use only the graphic protection options recommended in this Bulletin for this film.

- [3M™ Scotchcal™ Gloss Overlamine 8508](#)
- [3M™ Scotchcal™ Luster Overlamine 8509](#)
- [3M™ Scotchcal™ Matte Overlamine 8510](#)

Characteristics

These are typical values for unprocessed product. Processing may change the values.

Physical Characteristics

Characteristic	Value
Material	Vinyl
Film Color	White, opaque
Thickness	Without adhesive: 3.25 mil (0.081 mm) With adhesive: 4.0 mil (0.102 mm)
Adhesive	Pressure sensitive
Adhesive Color	Gray
Liner	Polycoated paper
Flammability	ASTM E84 reports: IJ35-10 and IJ35-20 , or go to the On-line Product Catalog at 3Mgraphics.com

3M™ Scotchcal™ Graphic Film

Application Characteristics

Characteristic	Value
Finished Graphic Application Recommendation	Surface type: Smooth, flat and simple curved surfaces Substrate type: Metal, rigid plastic and painted surfaces Application temperature: 40° – 100°F (4° – 38°C) air and substrate Application method: Dry
Temperature Range After Application	-59 °F to +192 °F (-50 °C to +90 °C) (not for extended periods of time at the extremes)
Graphic Removal	Permanent

Warranty Information

Warranty Coverage Overview

The warranty coverage for eligible graphics is based on the user both reading and following all applicable and current 3M Graphics Product and Instruction Bulletins. The warranty period for eligible graphics is as stated in the 3M Graphics Warranties Matrices at the time that the film was purchased. Information found at 3MGraphics.com/warranties includes:

- [3M Graphics Warranties Bulletin](#)
 - This bulletin contains information on limitations and exceptions, and warranty period reductions for 3M Graphics Warranties. The warranty period may be reduced and stipulations may apply for certain constructions, applications, and graphic exposures as covered in this Bulletin.
- [3M Graphics Warranties Selector](#)
 - Use this selector to search for your vertical warranty period by product type, ink type, film name, and/or ink/printer platform.
- [U.S. Desert Southwest Region Map](#)
 - Use this map of hot, arid desert areas to determine if you are subject to reduced warranted durabilities.

The warranties set forth in this Bulletin are made in lieu of all other express or implied warranties, including any implied warranty of merchantability, fitness for a particular purpose, or arising out of a course of dealing, custom, or usage of trade.

3M Basic Product Warranty

3M Graphics Products are warranted to be free of defects in materials and manufacture at the time of shipment and to meet the specifications stated in its applicable 3M Graphics Product Bulletin and as further set forth in the [3M Graphics Warranties Bulletin](#).

Limited Remedy

The limited remedy applicable to each warranty is addressed in the 3M Graphics Warranties Bulletin found at 3MGraphics.com/warranties.

Limitation of Liability

Except where prohibited by law, 3M SHALL NOT UNDER ANY CIRCUMSTANCES BE LIABLE TO PURCHASER OR USER FOR ANY DIRECT (EXCEPT FOR THE LIMITED REMEDY PROVIDED IN THE 3M GRAPHICS WARRANTIES BULLETIN), INDIRECT, SPECIAL, INCIDENTAL, OR CONSEQUENTIAL DAMAGES (INCLUDING, BUT NOT LIMITED TO, LABOR, NON-3M MATERIAL CHARGES, LOSS OF PROFITS, REVENUE, BUSINESS, OPPORTUNITY, OR GOODWILL) RESULTING FROM OR IN ANY WAY RELATED TO 3M'S GRAPHICS PRODUCTS, SERVICES, or THIS BULLETIN. This limitation of liability applies regardless of the legal or equitable theory under which such losses or damages are sought.

Additional Limitations

See the 3M Graphics Warranties Bulletin at 3MGraphics.com/warranties, for terms, additional limitations of your warranty, if any, information on reduced warranties for different exposures, and limitations of liability.

Factors that Affect Graphic Performance Life

The actual performance life of a graphic is affected by:

- the combinations of graphics materials used.
- complete ink drying or curing.
- selection, condition and preparation of the substrate.
- surface texture.
- application methods.
- angle and direction of sun exposure.
- environmental conditions.
- cleaning or maintenance methods.

Graphics Manufacturing



CAUTION

Before using any equipment, always read the manufacturer's instructions for safe operation.

Inkjet Printing

Always read and follow the ink manufacturer's written instructions on usage.

- **Sheeted film:** When used on a flat-bed inkjet printer, sheeted film may produce printing defects.
- **Ink limiting:** The recommended maximum ink limit is 250%.
- **If sheeted or stacked graphics will be stored:** If you plan to store sheeted and stacked finished graphics for an extended period of times, leave an unprinted margin (about 1/4 inch) to allow for possible shrinkage before trimming the graphic.

Do not exceed the recommended total ink coverage for the ink series used on this film. Having too high a total physical ink amount on the film results in media characteristic changes, incomplete drying, overlamine lifting, and/or poor graphic performance.

Completely Dry Graphics



IMPORTANT NOTE

Incomplete drying or curing can result in graphic failure including curling, increased shrinkage and adhesion failure, which are not covered under any 3M Graphic Warranty.

See the ink's 3M Product and Instruction Bulletin for more details.

Screen Printing

Formulations and processing conditions can affect ink durability. Refer to the Product and Instruction Bulletins for your ink for limitations and proper usage.

Cutting

See [3M Instruction Bulletin 4.1](#) for Sheeting, Scoring and Film Cutting details.

Graphic Protection

Graphic protection may improve the appearance, performance and durability of the graphic. Click on the graphic protection options listed in Product Bulletin or see the [3M Graphics Market Product Catalog](#), for more information.



IMPORTANT NOTE

During installation, scratches may occur on films without graphic protection.

Application and Installation

In addition to other 3M Bulletins specified in this document, the following Bulletins provide details that you may need to successfully apply a graphic.

- [3M Instruction Bulletin 4.22](#). Hot and Cold Roll Lamination for 3M Overlaminates.
- [3M Instruction Bulletin 5.1](#) Select and Prepare Substrates for Graphic Application
- [3M Instruction Bulletin 5.19](#). Lamination, Application & Maintenance of Floor Graphics. Complete the Surface Preparation procedure found in this Instruction Bulletin prior to applying a graphic to a surface.
- [3M Instruction Bulletin 5.5](#) Application, General Procedures for Interior and Exterior Dry Application
- [3M Instruction Bulletin 6.5](#) Storage, Handling, Maintenance, and Removal of Films and Sheetings

Pressure-sensitive Adhesive

This film has a pressure-sensitive adhesive. It bonds to the surface even with light pressure and cannot be repositioned.

Maintenance and Cleaning

Use a cleaner designed for high-quality painted surfaces. The cleaner must be wet, non-abrasive, without solvents, and have a pH value between 3 and 11 (neither strongly acidic nor strongly alkaline). See [3M Instruction Bulletin 6.5](#) for details.

Shelf Life, Storage and Shipping

Shelf Life

The shelf life is **never more than 2 years** from the date of manufacture on the original box.

If you process the film, the shelf life is changed to **1 year** from the processing date, but not later than the 2 year maximum from the manufacturing date.

Storage Conditions

- 90 °F (32 °C) maximum
- Out of sunlight
- Clean, dry area
- Original container
- Bring the film to print room temperature before using

Shipping Finished Graphics

Flat, or rolled printed side out on 5 inch (13 cm) or larger core. This helps prevent the liner, if used, from popping off.

Health and Safety



CAUTION

When handling any chemical products, read the manufacturer's container labels and the Safety Data Sheets (SDS) for important health, safety and environmental information. To obtain SDS sheets for 3M products go to 3M.com/SDS, or by mail or in case of an emergency, call 1-800-364-3577 or 1-651-737-6501.

When using any equipment, always follow the manufacturer's instructions for safe operation.

Bulletin Change Summary

For the most current 3M Technical Information available to successfully use this product, please view this Bulletin electronically and click on the blue underlined links to view the relevant documents.

Release J, NOV-2016:

- Updated Thickness. See "Physical Characteristics" on page 1.

3M Commercial
Solutions
3M Center
Building 220-12E-04
St. Paul, MN 55144-1000
Phone 1-888-328-3908
Web 3M.com/Graphics

3M Canada
PO Box 5757
London, ON N6A 4T1
1-800-265-1840
Fax 519-452-6245

3M México S.A. de C.V.
Av. Santa Fe No. 55
Col. Santa Fe, Del. Alvaro
Obregón
México D.F. 01210
General 5255-5270-0400
Fax 5255-5270-2277

3M Puerto Rico, Inc.
350 Chardon Avenue
Suite 1100
San Juan, PR 00918
General 787-620-3000
Fax 787-620-3018

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